

Duplicate.

Date: Thursday, 08/05/2008 7:51:52 AM  
 User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARING ASSEMBLY
Job Number : 38996	
Estimate Number : 11136	
P.O. Number :	Part Number : D3183045
This Issue : 08/05/2008 S.O. No. :	Drawing Number : D3183 REV C1
Prsht Rev. : NC	Project Number : N/A
First Issue : 02/05/2008 Type : MACHINED PARTS	Drawing Revision : C1
Previous Run : 38983	Material :
Written By : <u>[Signature] 08-05-08</u>	Due Date : 15/05/2008 Qty: <u>40</u> Um: Each
Checked & Approved By :	
Comment : Est A 04.02.18 New issue KJ/DS	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELRLNR1000	Delrin Round Bar 1"
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Comment: Qty.: 0.0350 f(s)/Unit Total : 0.6993 f(s)

Delrin Round Bar 1"

Material: Ø1.00 Delrin Rod

(M-DELRIN-R1.000)

Identify as D3183-9

Batch M04346

mmf 08/05/10

(40)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

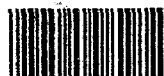
Turn D3183-9 Cap as per Folio FA388

Deburr

mmf 08/05/10

(40)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 08/05/10

(40)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

08/05/12 (x40)

5.0	D31835	Bearing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3183-5

Bearing

B38997

(27)

08/05/15

PTO  
cust page

(40)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 38996

Part Number: D3183045

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

*ml 08/05/15 x27*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/05/15 (22)*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST233 A

*JS 08/05/15 x27*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*0 08/05/16*

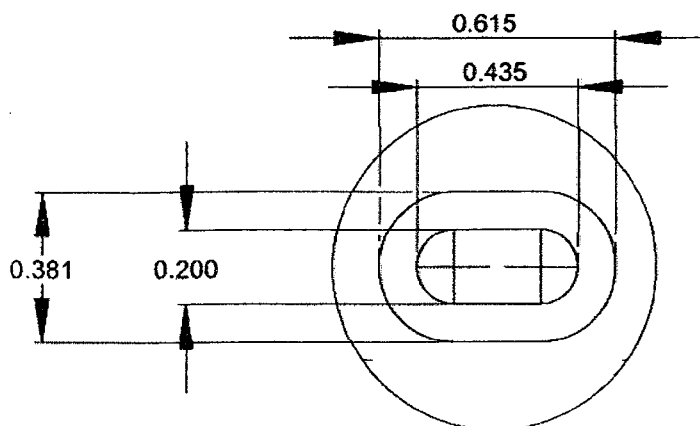
Job Completion



*MF 08-05-16*

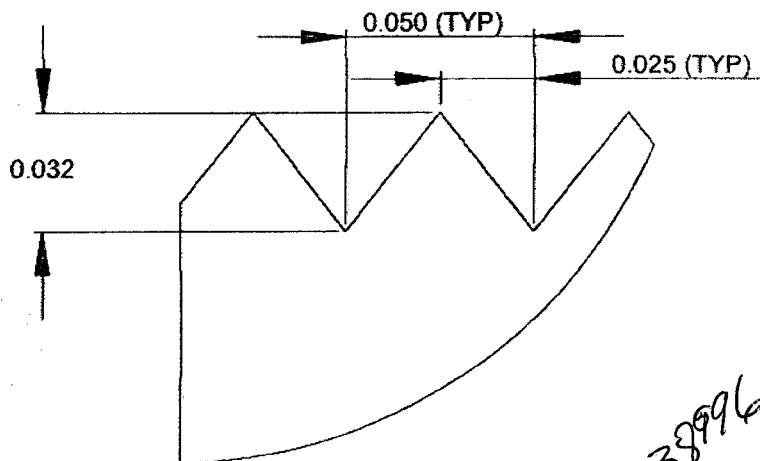


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3183</b>	REV. C SHEET 4 OF 4
DATE <b>04.02.17</b>		TITLE <b>BRACKET ASSEMBLY</b>	SCALE 1:1



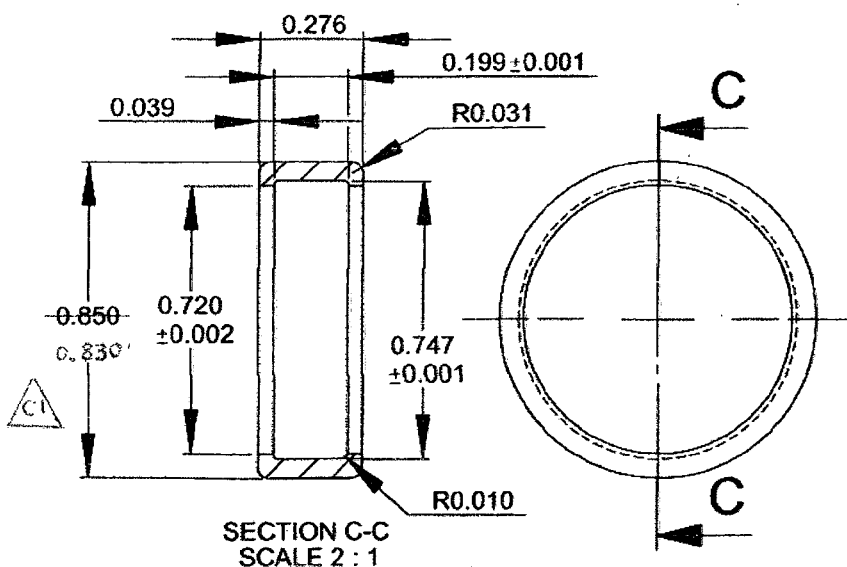
DETAIL A (2 : 1)

RELEASED  
04.03.01 *[Signature]*



DETAIL B (20 : 1)

w/o 38996



**D3183-9 CAP**

- 1) MATERIAL: DELRIN ROD, Ø1.00  
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3183-045 BEARING ASSEMBLY**

- 1) ASSEMBLE D3183-5 BEARING AND  
D3183-9 CAP

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WIO: 38996

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/05/15	5	put back stock B D 3183-9 <div style="border: 1px solid black; border-radius: 50%; padding: 5px; display: inline-block;">ST. 75</div>	DS	08/05/15	X13 ST. 75		S 08/05/15

 Part No: D 3183-045 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries